

Work Order ID 152639

Tuesday, November 01, 2016 2:34:50 PM

152639

Page 1

Item ID: D2121 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Clamp Assembly
Start Date: 11/16/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 12/1/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: ^{DAS} 21 Date: **NOV 01 2016** Tooling: Date: Run Start ***NR1***
QC: ⁹⁻⁸⁹ Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2121	Rev D								

100 0.00
100 Large Fab
Large Fab Memo 0.13
Large Fab Weld washer & wing nut as per Dwg D2121 & QSI 004
Identify as Wing Nut assembly
4 16-11-2

110 0.00
110 QC Memo 0.00
Quality Control
4 16-11-15 ^{DAS} 9-89

120 0.00
120 Small Fab
Small Fab Memo 0.42
Small Fab Assemble parts from steps 5-14 and Wing Nut Assembly as per Dwg D2121.
Drill and deburr hole in coupling nut as per Dwg D2121.
(Note: Install MS21042L4 Nut loosely)
Cut D2771-BCFC-025-150 at 1.500"
4 FF NOV 17 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Description Work Order Deviation				Disposition																																																													
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01				<u>4</u>			DAS 38 9-89 NOV 17 2016
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>Stock</u> Memo	0.00 0.01				<u>4</u>			DAS 6 9-89 NOV 18 2016
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.07							<u>16/11/21</u> <u>df</u> DAS 21 9-89 DAS NOV 18 2016

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By 		
							Lead hand / Supervisor Approval Verification 		
							QC / QA Coordinator Approval 		

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

Picklist Print

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Page 1

Work Order ID: 152639

152639

Parent Item: D2121

D2121

Parent Item Name: Clamp Assembly

Start Date: 11/16/2016

Required Date: 12/1/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: D04.05.27Added Step 2-3; changed Step 4 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

5/16-18 SS JAM NUT		Purchased	No			120	Each	98.0000	1	4			
										**	FF	NOV 17 2016	
5/16-18 SS JAM NUT													
Jam Nut													

Location	Loc Qty	Loc Code
GA	53	
110084	53	
Mezz	45	
16016	45	

5/16-18 SS THREADED		Purchased	No			120	f	27.0000	0.541	4			
										**	FF	NOV 17 2016	
5/16-18 SS THREADED													
Threaded Rod 6.5" long													

Location	Loc Qty	Loc Code
GA	27	
121239	15	
121486	12	

5/16-18 SS WING NUT		Purchased	No			100	Each	100.0000	1	4			
										**	FF	NOV 17 2016	
5/16-18 SS WING NUT													
Wing Nut													

Location	Loc Qty	Loc Code
Mezz	100	
110084	100	

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

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Work Order ID: 152639

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Parent Item: D2121

D2121

Parent Item Name: Clamp Assembly

Start Date: 11/16/2016

Required Date: 12/1/2016

Start Qty: 4.00

Required Qty: 4.00

5/16-18SS1COUPLING

Purchased

No

120

Each

29.0000

1

4

5/16-18SS1COUPLING

FF

NOV 17 2016

Coupling Nut mcmaster p/n: 90268A030

Location

Loc Qty

Loc Code

GA

27

M130477

27

Mezz

2

16016

2

5/16WC

Purchased

No

100

Each

881.0000

1

4

5/16WC

12/16/12

Washer

Location

Loc Qty

Loc Code

ST583

881

m135850

881

AN4-4A

Purchased

No

120

Each

98.0000

1

4

AN4-4A

FF

NOV 17 2016

BOLT

Location

Loc Qty

Loc Code

ST346

98

m129390

98

D2012-107

Manufactured

No

120

Each

13.0000

1

4

D2012-107

FF

NOV 17 2016

Clevis

Location

Loc Qty

Loc Code

WA004

13

149315

13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
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Page 3

Work Order ID: 152639

152639

Parent Item: D2121

D2121

Parent Item Name: Clamp Assembly

Start Date: 11/16/2016

Required Date: 12/1/2016

Start Qty: 4.00

Required Qty: 4.00

D2529 Manufactured No 120 Each 427.0000 5 20

D2529

Washer

FF

NOV 17 2016

Location

Loc Qty

Loc Code

ST008

427

150080

427

20

D2771-BCFC-025-150

Manufactured No

120 Each

700.0000

1

4

D2771-BCFC-025-150

Bolt

FF

NOV 17 2016

Location

Loc Qty

Loc Code

GA

29

8754

29

4

Mezz

671

8754

671

D2771-LCC-025

Manufactured No

120 Each

685.0000

1

4

D2771-LCC-025

Lock Nut

FF

NOV 17 2016

Location

Loc Qty

Loc Code

GA

97

8493

97

4

Mezz

588

4554

6

8493

582

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER :			
Misidentified ☐	☐	Past Due	☐				

Picklist Print

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Work Order ID: 152639

152639

Parent Item: D2121

D2121

Parent Item Name: Clamp Assembly

Start Date: 11/16/2016

Required Date: 12/1/2016

Start Qty: 4.00

Required Qty: 4.00

MS21042L4 Purchased No 120 Each 2,453.000 1 4
MS21042L 4 ** FF NOV 17 2016
Nut

Location	Loc Qty	Loc Code
FP001	34	
m133363	34	
GA	260	
m135058	260	
OVER007	1500	
m135774	500	
m135864	1000	
ST303	659	
m135704	159	
m135979	500	

NAS1149D0463J Purchased No 120 Each 2,699.000 1 4
NAS1149D0463.J ** FF NOV 17 2016
Washer

Location	Loc Qty	Loc Code
cnc	200	
M135671	200	
GA	135	
M134508	32	
M135056	103	
ST260a	2000	
M135767	1000	
M135948	1000	
ST263	364	
M135530	30	
M135671	334	

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Shop Packet Print

Page 4

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Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

SHOP COPY

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ENGINEERING

UNCONTROLLED COPY

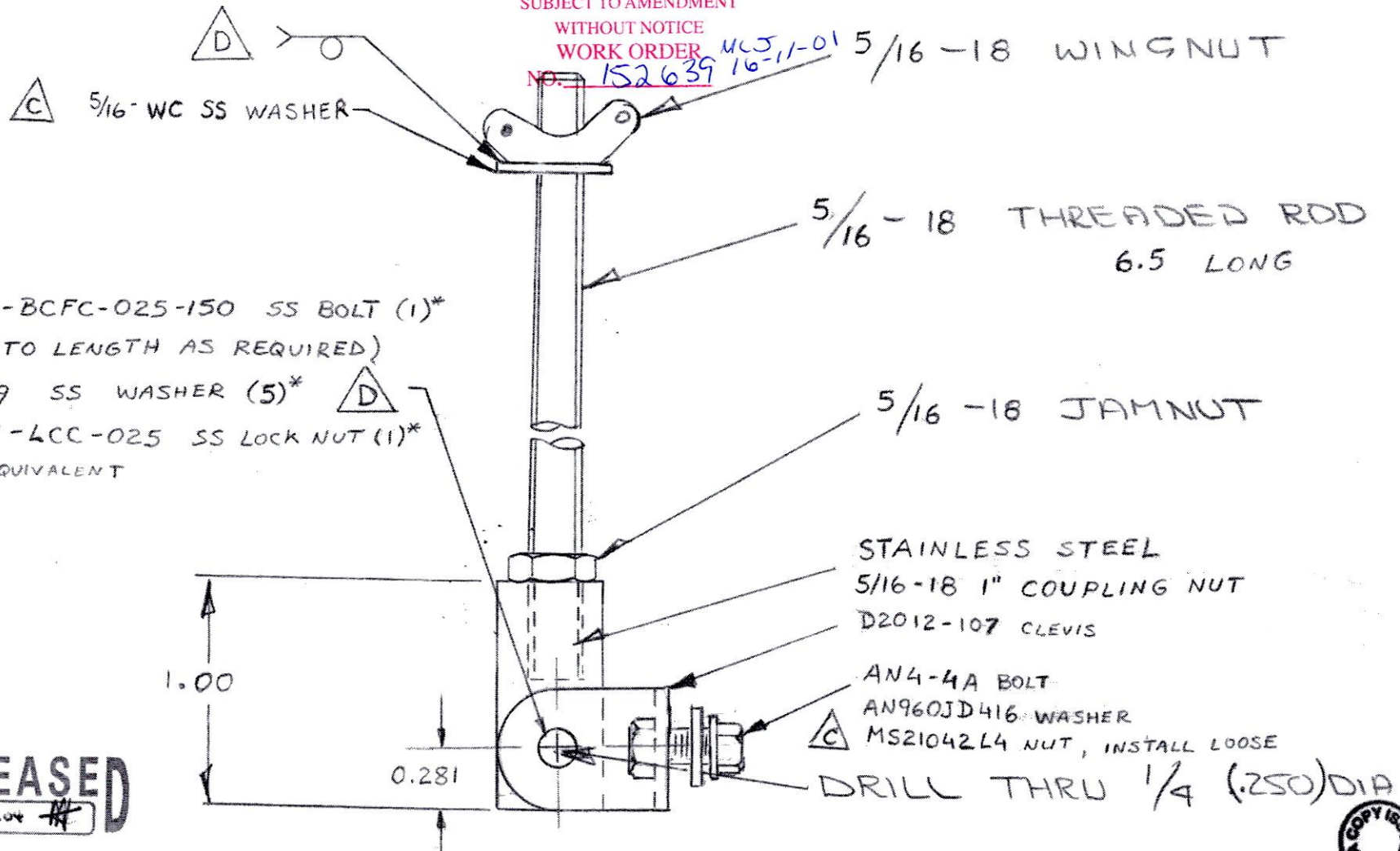
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 152639

405-11-01 5/16-18 WING NUT



D2771-BCFC-025-150 SS BOLT (1)*
(CUT TO LENGTH AS REQUIRED)

D2529 SS WASHER (5)*

D2771-LCC-025 SS LOCK NUT (1)*

*OR EQUIVALENT

RELEASED
04.05.04



D	C	B	-	REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER NAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR														
RF	RF	RF	JB	DRAWN		BASIC CODE	DA, DASH NO. W-HEAD NEAR SIDE F-HEAD FAR SIDE	CONTRACT NO.		DART DART AERO ACCESSORIES INC. VANCOUVER CANADA																
RF	RF	RF	JB	APPROVED		D-DIMPLE DASH NO. OF SHEETS C-COUNTERSINK	LENGTH DASH NO. W-SPOTWELD	DATE	DRAWN		CLAMP, BATTERY															
RF	RF	RF	JB	DESCRIPTION OF CHANGE		BASIC CODES		DATE	DESIGN	STRESS	CHECKED	CLIENT	DWG NO. DZ121 SCALE NTS SHT 1 OF 1													
ADDED NOTES 04.04.15 ADDED FASTENERS 03.01.17 REV. DIM 99.08.18 NEW ISSUE 92.03.07					REQUIREMENTS — UNLESS OTHERWISE SPECIFIED <table border="1"> <tr> <th>GENERAL</th> <th>LIMITS</th> </tr> <tr> <td>1. DIMENSIONS ARE IN INCHES</td> <td>1. TOLERANCES — .JXX & .J30</td> </tr> <tr> <td>2. SURFACE ROUGHNESS 125</td> <td>2. ANGLES XXX & .010</td> </tr> <tr> <td>3. REMOVE SHARP EDGES .015 MAX</td> <td>3. PARALLELISM 1.0025</td> </tr> <tr> <td>4. THREADS PER INCH — 5 — 7342</td> <td>4. ECCENTRICITY .005 MAX</td> </tr> <tr> <td>5. HOLES PER AND 10287</td> <td>5. SYMMETRY ABOUT ALL 3/4" CENTRE LINES .005</td> </tr> </table>		GENERAL	LIMITS	1. DIMENSIONS ARE IN INCHES	1. TOLERANCES — .JXX & .J30	2. SURFACE ROUGHNESS 125	2. ANGLES XXX & .010	3. REMOVE SHARP EDGES .015 MAX	3. PARALLELISM 1.0025	4. THREADS PER INCH — 5 — 7342	4. ECCENTRICITY .005 MAX	5. HOLES PER AND 10287	5. SYMMETRY ABOUT ALL 3/4" CENTRE LINES .005	REPORT ALL DISCREPANCIES — DO NOT SCALE							
GENERAL	LIMITS																									
1. DIMENSIONS ARE IN INCHES	1. TOLERANCES — .JXX & .J30																									
2. SURFACE ROUGHNESS 125	2. ANGLES XXX & .010																									
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4. THREADS PER INCH — 5 — 7342	4. ECCENTRICITY .005 MAX																									
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